Work Order ID	114518
---------------	--------

Page 1

Friday, March 07, 2014 9:20	D:30 AM									8
Item ID: D3391-025 Revision ID: Item Name: Aft Tube Asset Start Date: 3/7/2014	-	*1*	Accept	*N900		100)*		^{art} *	NS1* NS2*
Required Date: 3/14/2014	Start Qty: 1.00 Req'd Qty: 1.00	^		Cust Item : Customer:	ID:					
Reference:		^1^		Customer:	. •	•	•			<u></u>
Approvals: Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:]		art * op *	NR1* [©] NR2*
Sequence ID/ Work Center ID	Operation Description	,	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numb	t Insp.
	vision Nbr									
D3391 I							· · · · · · · · · · · · · · · · · · ·			
100 Mori Seiki Mori Seiki CNC Lathe Large	MORI SEIKI CNC LAT Memo Turn as per		0.00 0.00 1 & Dwg D3391 Rev: /	_				<u> </u>	- · · ·	Nim. L 14/03/38
110	QC2- Inspect parts off n	nachine FAI/FAIB	0.00				ı	1		
110 QC Quality Control	Memo		0.00							mml 14/03/00
112 *11	QC5- Inspect part comp	leteness to step on W/O	0.00 54/3/	Q		1	_/		· ·	

DQA:			Date:			• .							
						WORK ORDER NON	-C(ONFO	RMANCE / UPD	ATE			_ AEROSPACE
QA Closed:			Date:				_			W	ork Order up	date only	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	,
Part I	-					Rework Scrap Use-as-is Suspected Unapproved		Thern	Machining S noforming	Crosstube Small Fab Finishing omposite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Desci	ription of work order update	!	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	ling Gear					,							
							FAI	ULT CAT	TEGORY				
Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube						General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misreac Off-set	on Incomplete/Unqua ions Incomplete/Uncle ned/off center led		Outside Dime Over/Under Part Incorrect Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance it ssing /rong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence				

<u> </u>	-								Make manager A	
Work Ore Friday, March	der ID 11 <i>a 07, 2014 9:2</i>			*114	.518*					Page 2
Item ID: Revision ID:	D3391-025			Accept	*N90004	010 0)* s	Setup Sta	17	S1*
Item Name: Start Date: Required Dat Reference:	Aft Tube Ass 3/7/2014 re: 3/14/2014	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:			Sto	[₽] *N	S2*
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date:		F	Run Sta Sto	^ \ \ 	R1* R2*
Sequence ID/ Work Center 120 *1 20* HAAS 1 HAAS CNC verti	·	Operation Description HAAS CNC VERTICAL Memo		Set Up/ Run Hours 0.00 0.00 v: AA & Dwg D3391 Rev:	Tool ID Too	Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 149-89
130 *130* QC Quality Control	car machine #1	2-Deburr QC2- Inspect parts off m		0.00	ml 14/03/1	7_		Ø		DAS 14 9-89

0.00

0.00

Da 4/03/19

140

Quality Control

QC8- Inspect parts - second check

Memo

INSPECT INSIDE BORE

DQA:			Date:										TORCE
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only	
Work Orde	∍r:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Work Oral						Rework	1		Skid-tube Crosstub	- آ	1	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining Small Fa		Pro	d. Eng. Coor.	* Quality
	,					Use-as-is	1		noforming Finishir	g	1	re/Packaging	Other
NCR 1	VO.					Suspected Unapproved]		Large Fab Composit	e].	Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													, .
Doc/Data :													<u> </u>
Equip/Tooling													
Handling/Pre						<u>}</u> .							
Material -													
Operator.	rator.^												
Offset/Setup					ŕ	;	`						
Process						.							
Supplier Training		·		·		· · · · · · · · · · · · · · · · · · ·							,
Transport													
Unapproved							İ					•	·
			•	· <u>·</u>			FAI	ULT CAT	regory	,	*		
Landi	ng (Gear				General					_		
·		Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up Set-up
#		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	-	Temperature/Cure
		Crimp/Kir	nk/Ripple	e/Wave		Burrs	L	4	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		1	ions Incomplete/Unclear	\perp	Part Moved	. L	Wrong Stock Pulled `
		Crushing				Countersink	<u></u>	1 -	ned/off center	\perp	Positioned V	_	¬
		Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	Surge	Other
		Inspection		Tube	-	Drawing	<u></u>	Misread					
		Marks/Ch			-	Drill Holes	\vdash	Off-set					
	_	Turning S				Finish	\vdash	1.	Calibration				
	l	Wave/Tw	ist in Tub	oe -	. I	Fit/Function	1	Jout of S	Sequence				

Work Order ID 114518

114518

Page 3

	Friday, March	07, 2014 9:2	20:30 AM			FO LO.						1 age 3
9	Item ID: Revision ID: Item Name:	D3391-025 Aft Tube Ass			Accept	*N900	040	100)*	Setup Star Stop	1.71	S1*
4	C44 D-4	3/7/2014	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:			·	^I\\	S2*
	Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:]	Run Star	~1 <i>\</i> 1	R1*
	r	QC:		Date:	SPC (Y/N):	D	ate:			Sto	, *N	R2*
	Sequence ID/ Work Center I	D	Operation Description	—4.60.	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	150 Skidtubes		Skidtubes Memo		0.00				oc/	1/03/19	j	
. 4	Skidtubes	· · · · · · · · · · · · · · · · · · ·	1-Drill (PIL	OT HOLE) aft cap hole	s per Dwg D3391 using DT	T8803			•	· /	•	`
	160		BENDING MACHINE -	SKIDTURES	0:00				~ .			
	160 CNC Bend 1 CNC Delta 100 Ben	nder	Memo	Dwg D3391 Using Be	0.00 nd Prog 3391025				- DC	19/0	3/25	
•								•		,		
	170		QC5- Inspect part comple	eteness to step on W/O	0.00		Ó	AS .) ,,,	12 -	7
	QC Quality Control	106.	Memo		0.00		·	03 989	T	77		ナラ

H 4.24"

DQA:			Date:											DA DT
						WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE				AEROS PACE
QA Closed:			Date:								W	ork Order up	date only	
						DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Work Orde	er: _								—	1		•	٠	
D						Rework			Skid-tube	Crosstube	_		Water Jet	Engineering
Part N	NO					Scrap			Machining	Small Fab			d. Eng. Coor.	Quality . Other
NCR N	J۵					Use-as-is Suspected Unapproved		merr	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	- Other
NCKT	•0				_	Juspected Oliappioved			raige lab	Composite			20ppilei [
Root			i		Descr	ription of work order update		nitial	Act	tion		Sign &		
Cause	l	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
Design						,								
Doc/Data						· ·								
Equip/Tooling	_													
Handling/Pre														
Material	Ш													
Operator														
Offset/Setup	\Box													
Process						*								
Supplier														
Training	Щ													
Transport	Ц	~~~					İ							
Unapproved		<u> </u>					<u></u>							
							FAU	JLT CA	regory				<u> </u>	
Landi						General		 1:-/6	\		_	ام بدنیا منت	Г	¬¬¬¬¬¬¬
	-	Bending			. —	Bend BOM/Route		l '	Program		_	Outside Dim	 	Pressure/Forced Set-up
	\vdash	Centre No	t Concer	itric .	-	BOM/Route	\vdash	Grain			_	Over/Under Part Incorred	<u> </u>	Temperature/Cure
	-	Cracks Crimp/Kin	là/Dinnl-	Minus	-	Broken/Damage/Defect	\vdash	Hardwa	ire ion Incomplete/Ui	ngualified	\vdash	Part Incorred	 	Weld
				/ wave	,	Burrs ्रेक् Contamination			tions Incomplete/	•	-	Part Moved	· -	Wrong Stock Pulled
Cuffs Crushing						Countersink		1	ned/off center	Officical .	\vdash	Positioned V	·	
Heat Treat						Cut Too Short	\vdash	Mislabe	•			Power Loss/		Other
	$\boldsymbol{\vdash}$	Inspection		Tube		Drawing		Misrea			L]. 0410, 2033/.	Bc	- Carlot
	-	Marks/Ch	7 .	Tabe		Drill Holes	\vdash	Off-set		*				
	-	Turning Se				Finish	\vdash	ł	Calibration					
	_	Wave/Twi			·	Fit/Function		1	Sequence				:	

Page 4

Friday, March 07, 2014 9:20:30 AM Item ID: D3391-025 Accept *N900040100* Setup Start **Revision ID: Item Name:** Aft Tube Assembly **Start Date:** 3/7/2014 Start Qty: 1.00 **Cust Item ID: Required Date: 3/14/2014** Req'd Oty: 1.00 **Customer:** Reference: Run Start Process Plan: **Approvals:** Tooling: Date: Date: Stop QC: Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Reject **Work Center ID** Description **Run Hours** Code **Qty** Qty Number Stamp 180 0.00 Skidtubes *120* Skidtubes 0.00 De 14/04/02 Skidtubes 1-Open Aft cap pilot hole to .208" as per Dwg D3391 2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only. 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig. *****Do Not Open To Finished Size***** 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5-Open wearplate holes to 0.297" and c'bore as per dwg D3391 6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 7-Deburr 8- Scribe batch # on fwd end

DQA:			Date:											NA PT
						WORK ORDER NON	-C(ONFO	RMANCE / UPD	ATE				AEROSPACE
QA Closed:			Date:							V	Vork Ordei	update	only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTME	NT/PRO	CESS	
	-					Rework	1		Skid-tube (Crosstube	7	w	ater Jet	Engineering
Part N	lo.					Scrap	1			Small Fab	-		g. Coor.	Quality
	-				_	Use-as-is	1 .		noforming	Finishing			ckaging	Other
NCR N	۱o					Suspected Unapproved]		~ —	Composite			Supplier	
Root				-	Desci	ription of work order update	- 1	nitial	Action	· · · · · · · · · · · · · · · · · · ·	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descripti	ion	Date		rification	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material													•	
Operator	tor													
Offset/Setup							1							
Process														
Supplier					′		1							
Training														
Transport												l		
Unapproved		•		L <u>.</u>	•									
			•				FAI	ULT CAT	TEGORY					
Landi						General		1 ,_		_	٦		_	1
	-	Bending				Bend	_	· ·	rogram		Outside [—	Pressure/Forced
	Centre Not Concentric					BOM/Route	-	Grain		<u> </u>	Over/Und		ance	Set-up
	Cracks					Broken/Damage/Defect	-	Hardwa		<u> </u>	Part Inco		<u> </u>	Temperature/Cure
ž	Crimp/Kink/Ripple/Wave					Burrs	-	i '	on Incomplete/Unqua	 	Part Lost,	_		Weld
*	Cums					Contamination	\vdash	1	ions Incomplete/Uncl	ear	Part Mov			Wrong Stock Pulled
	Crushing Heat Treat					Countersink	-		ned/off center		Positione	_	_]]
	Inspection Strip in Tube					Cut Too Short	\vdash	Mislabe		L	Power Lo	ss/surge	<u> </u>	Other
	Marks/Chatter					Drawing Drill Holes	<u> </u>	Misread	1		·			
	-				-		\vdash	Off-set	Calibration		-			
	$\overline{}$	Turning Se			-	Finish	\vdash	ł	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function	L	Out of S	Sequence					

Work Order ID 114518

114518

Page 5

Friday, March 07, 2014 9:20:30 AM Item ID: D3391-025 Accept *N900040100* Setup Start **Revision ID: Item Name:** Stop Aft Tube Assembly Start Date: 3/7/2014 Start Qty: 1.00 *1* **Cust Item ID: Required Date: 3/14/2014** Req'd Qty: 1.00 *1* **Customer:** Reference: Run Start Approvals: Date:_____ Process Plan: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID Description Run Hours** Qty Code Oty Number Stamp 190 QC5- Inspect part completeness to step on W/O 0.00 *100* 14-04-04 QC 0.00 Memo Quality Control 200 Chemical Conversion Coat per QSI005 4.1 0.00 1 DCL 14-4-7 *200* HandFinish 0.00 Memo Hand Finishing 210 QC7-Inspect Chemical Conversion Coat 0.00 · 1 \$ DC 14/04/09 0.00 Memo Quality Control

DQA:			Date:										•	74	
						WORK ORDER NON	-C(ONFO	RMANCE / UP	DATE					AFROSPACE
QA Closed:			Date:								Wo	ork Order up	date only	•	ALKOO. NO.
Work Orde	٥r.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	٠,,					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	No.					Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	\dashv	Quality
						Use-as-is			noforming	Finishing	_		e/Packaging	\dashv	Other
NCR I	No.					Suspected Unapproved]		Large Fab	Composite			Supplier		
Root					Desci	ription of work order update		nitial	Actio	on		Sign &		Ŧ	-
Cause		Date	Step	Qty		or non-conformance	l	ief Eng	i e			Date	Verification	,	QC Inspector
Design														\dashv	
Doc/Data						•					·				
Equip/Tooling															
Handling/Pre							'		.,						
Material															<u>.</u>
Operator												,			•
Offset/Setup 1									·.						
Process								•							
Supplier															
Training													÷		
Transport															
Unapproved				<u> </u>			501	UTCAT	TECODY			<u> </u>			
Landi		5025				General	FAI	JLI CA	regory						
Langi	ng (Bending				Bend		Folio/D	Program			Outside Dim	onsions [\neg	Pressure/Forced
			nt Concer	ntric		BOM/Route		Grain	Togram		H	Over/Under		_	Set-up
	Centre Not Concentric					Broken/Damage/Defect	\vdash	Hardwa	aro.		Н	Part Incorred	F	_	Temperature/Cure
	Cracks Crimp/Kink/Ripple/Wave					Burrs			ion Incomplete/Unq	ualified	-	Part Lost/Mi	- F		Weld
	Cuffs					Contamination		1. 4	tions Incomplete/Ur			Part Moved	 		Wrong Stock Pulled
	Crushing					Countersink			ned/off center	. = : • • •		Positioned V			
•	_	Heat Trea	t			Cut Too Short		Mislabe	•			Power Loss/	, r	\neg	Other
		Inspection		Tube		Drawing		Misread				1	~ L		
		Marks/Ch				Drill Holes		Off-set							•
		Turning Se	equence			Finish		Out of (Calibration						
		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence						

Page 6

Friday, March	07, 2014 9:20	0:30 AM		114	F: 1 I O						1460
Item ID: Revision ID: Item Name:	D3391-025 Aft Tube Asse	ombly.		Accept	*N900	040	100)* ፡	Setup Star Sto	171	S1*
Nem Name: Start Date: Required Date Reference:	3/7/2014	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:			510	* *N	S2*
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		nte:	- ·	F	Run Star Sto	^ \	R1* R2*
Sequence ID/ Work Center I 220 *720* Skidtubes Skidtubes	I D	A/R Magn exp. date: _cure time 12	acers as per dwg D3391 abond 6398 Batch: 14/05/05/ Phrs as per QSI0015 possbolts flush	Set Up/ Run Hours 0.00	Tool ID De 14/04/09	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230 *230 QC Quality Control		4- Touchup 5- Deburr QC5- Inspect part compl	Magnabond eteness to step on W/O	0.00	707/71			0	14.04	15	DAS _0 9-89

DQA:			Date:											*	AA PT
						WORK ORDER NON	-CC	ONFO	RMANCE / UP				-		AEROSPACE
QA Closed:			Date:								W	ork Order up	odate only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		į
Part N	-					Rework Scrap Use-as-is Suspected Unapproved		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desci	ription of work order update		nitial	Actio	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	1	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	or Setup Sort Sort Sort Sort Sort Sort Sort Sort									·					
							FA	JLT CAT	TEGORY						
Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube					General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unditions Incomplete/Unditions Incomplete/Unditions Incomplete/Unditions Incomplete/Unditions Incomplete	· .		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
		Wave/Tw	ist in Tuh	٩		Fit/Function		Out of S	Sequence						

Page 7

Friday, March 07, 2014 9:20:30 AM Accept Item ID: D3391-025 Setup Start *N900040100* **Revision ID:** Stop **Item Name:** Aft Tube Assembly *1* **Start Date:** 3/7/2014 Start Oty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 **Required Date: 3/14/2014** *1* **Customer:** Reference: Run Process Plan: Date: Tooling: **Approvals:** Date: Stop Date:_____ SPC (Y/N): Date: QC: Tool ID Reject Sequence ID/ Set Up/ Tool # Plan Accept Reject Insp. **Operation** Number Stamp Qty **Work Center ID Description** Code Qty **Run Hours** 0.00 235 Pressure Wash per QSI005 4.3 76147.16 *235* 0.00 HandFinish Memo Hand Finishing AND REALODINE AS PER PAR09-043 White Gloss(Ref:4.3,5.1) per QSI005 4.3-Alum 0.00 1 \$ 14-7-16 240 *240* 0.00 Powdercoat Powder Coating 250 QC3- Inspect Part Finish 0.00 1 d Il 1107/16 *250* 0.00 QC Memo **Quality Control**

DQA:		<u> </u>	Date:	<u></u>		W05// 05555 NOV							1	ART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDATE	W	ork Order up	odate only	7	AEROSPACE
						DISPOSITION			AGAINST		PARTMENT			
Work Orde	er:						,			_	1		_	
						Rework			Skid-tube Crosstube	-		Water Jet		neering
Part N	۱o. <u> </u>	•				Scrap			Machining Small Fab	\vdash	4	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming Finishing	—	Rec/Sto	re/Packaging	_	Other
NCR N	1o. <u> </u>					Suspected Unapproved			Large Fab Composite	:	j	Supplier	<u> </u>	. 📙
Root					Descr	iption of work order update		nitial	Action		Sign &			
Cause	\perp	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	ı QC	Inspector
Design	_	•												
Doc/Data	_													
Equip/Tooling														
Handling/Pre														
Material						•								
Operator											,		ŀ	
Offset/Setup														
Process											, i			
Supplier														
Training														
Transport	٠,					•								
Unapproved														
							FAI	ULT CAT	regory					·
Landi	ng Gea	ar				General		_			-			
	B€	ending			/ <u> </u>	Bend		Folio/P	rogram		Outside Dim	ensions	Pressu	re/Forced
	Ce	entre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up)
z.3						Broken/Damage/Defect		Hardwa	re	L	Part Incorred	ct [Tempe	rature/Cure
· .	Crimp/Kink/Ripple/Wave					Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
2,5	Cuffs					Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wrong	Stock Pulled
	Crushing					Countersink		Misalig	ned/off center		Positioned V	Vrong _		
	Heat Treat					Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
	Inspection Strip in Tube					Drawing		Misread	b					
	Шм	arks/Ch	atter			Drill Holes		Off-set						
]Tu	irning Se	equence			Finish		Out of (Calibration					
	W	'ave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order ID 1145	1518
--------------------	------

Page 8

riday, March (07, 2014 9:20):30 AM			P. J I C J				
tem ID: Revision ID: tem Name:	D3391-025 Aft Tube Asse	embly		Accept	*N900	004010	n * :	Setup Start Stop	10.2 1
		·	*1*		C II	ID			
start Date: Required Date	3/7/2014	Start Qty: 1.00 Req'd Qty: 1.00	~ ^ *1*		Cust Item Customer:				
Reference:	· <i>5</i> /14/2014	Req u Qty. 1.00	^1^		Customer.		_		
Approvals:	Process Pla	n:	Date:	Tooling:	D	Pate:	-	Run Start	"INHI"
	QC:		Date:	_ SPC (Y/N):	D	Pate:	_	Stop	*NR2*
Sequence ID/ Work Center I	(D	Operation Description	,	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
60				0.00				1	am (
クらハ HandFinish		HandFinishing		0.00			11		14/02/16
Hand Finishing		⊂2-Install Aft A/R Sikafl Sikafle	erts as per Dwg D3391 Cap as per Dwg D3391 ex-241/-291 M 7 9 6 ex expiry date:	157					
270		QC5- Inspect part comp		0.00	1				
970 QC Quality Control		Memo		0.00	1117				
280		Identify as per dwg & Si	ock Location: (A)	0.00 0.112	717 013 1				
280		and the second second		0412-	742-043	13114904	1	_/	Il 167/18
Packaging Packaging		Memo		0.00				- - 4	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \

DQA:			Date:										DART.
						WORK ORDER NON	-C(ONFO	RMANCE / U				AEROSPACE
QA Closed:			Date:							V	Vork Order u	odate only	
Work Ord	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part I	_					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descr	ription of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	1	nief Eng		ription	Date	Verification	QC Inspector
Design			9106	~.,		or train comprimence		iici, Erig	200	TIPCION	Dute	Vermeation	Qe mspector
Doc/Data	H												
Equip/Tooling								:					
Handling/Pre													
Material		,	, .										
Operator													
Offset/Setup													
Process	П								-				·
Supplier	П							•					
Training													
Transport	П						1	:					
Unapproved	П												
				•••			FA	ULT CA1	EGORY				
Landi	ng Ge	ar				General							
	В	ending				Bend		Folio/P	rogram	Γ	Outside Dim	ensions	Pressure/Forced
	C	entre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	c	racks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct 🗍	Temperature/Cure
	Crimp/Kink/Ripple/Wave			/Wave		Burrs		Inspecti	on Incomplete/Ui	nqualified	Part Lost/Mi	ssing	Weld
	Cuffs					Contamination		Instruct	ions Incomplete/l	Unclear	Part Moved		Wrong Stock Pulled
•	·· Crushing					Countersink		Misalig	ned/off center	. [Positioned V	Vrong	-
	Heat Treat				Cut Too Short		Mislabe	led		Power Loss/	Surge	Other	
	Inspection Strip in Tube				Drawing		Misreac	I	_				
	Marks/Chatter					Drill Holes		Off-set					
	Turning Sequence					Finish		Out of 0	Calibration				
	Turning Sequence Wave/Twist in Tube					Fit/Function		Out of S	equence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

. 'e											
Work Ord				*112	1518*						Page 9
Item ID: Revision ID: Item Name:	D3391-025 Aft Tube Ass			Accept	*N900	040	100)* s	Setup Start	"I U .	S1* S2*
Start Date: Required Date	3/7/2014 e: 3/14/2014	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					17
Reference:							_	T.	tun Start	.l. N 1 1	5 4 3.
Approvals:	Process Pl	an:	Date:	Tooling: _	Da	ate:				*I/I	R1*
	QC:	,	Date:	_ SPC (Y/N):	Da	ate:			Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	_	Reject Number	Insp. Stamp
290		QC21- Final Inspection	- Work Order Release	0.00							

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

29U

Quality Control

MUS 14-07-17 MH-7-17

DQA:		_ Date:		· · · · · · · · · · · · · · · · · · ·				_				*	DART
04 (1		Data			WORK ORDER NON	-C(ONFO	RMANCE / UPDATE		101	, , , r		AEROSPACE
QA Closed:		Date:	****						W	ork Order u	odate only		
Work Orde	er:				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
					Rework	1		Skid-tube Crosstube]	Water Jet	\neg	Engineering
Part N	۱o.				Scrap	1 1		Machining Small Fab	—	Pro	d. Eng. Coor.	\exists	Quality
			•		Use-as-is		Thern	noforming Finishing		-1	re/Packaging		Other
NCR N	lo				Suspected Unapproved			Large Fab Composite]	Supplier		
Root				Desci	ription of work order update		I Initial	Action		Sign &	, -		
Cause	Date	Step	Qty		or non-conformance	Ch	nief,Eng	Description		Date	Verification	۱	QC Inspector
Design													
Doc/Data													
Equip/Tooling										}			
Handling/Pre													
Material													
Operator													:
Offset/Setup													
Process													
Supplier													
Training													
Transport													
Unapproved						<u> </u>							
						FAI	ULT CAT	regory					
Landi	ng Gear				General		-			•	-		
	Bending				Bend		Folio/P	rogram		Outside Dim	ensions		Pressure/Forced
	Centre I	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re	L	Part Incorre	ct		Temperature/Cure
	Crimp/k	Crimp/Kink/Ripple/Wave			Burrs		Inspect	on Incomplete/Unqualified	L	Part Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved	Ĺ		Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong		
	Heat Treat				Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
	Inspection Strip in Tube				Drawing		Misread	1			· · · · · · · · · · · · · · · · · · ·		
	Marks/Chatter				Drill Holes		Off-set						
ļ	Turning	Sequence		Ŀ	Finish		Out of 0	Calibration					
	Turning Sequence Wave/Twist in Tube				Fit/Function		Out of S	Sequence			. —		

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print

Friday, March 07, 2014 9:20:35 AM

Work Order ID: 114518

114518

Parent Item:

D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 3/7/2014

Required Date: 3/14/2014

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev B 06-02-07

06-03-28

ECN773 dwg rev. D EC Update Manuf. Instructions JLM

IPP Rev:C IPP rev D 07.03.20

revF dwg EC

IPP rev E 07.11.07

rev G dwg ecn 1053p EC verified by: DD

IPP Rev:F 07-11-13

ECN 1056

DD verified by: EC

IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H

11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D4095-047		Manufactured	No		-	260	Each	18.0000	1	1		ľ
*D4095-04 Wearpad Assembly	47 *								**	}	U,	402/14
				Location	<u>!</u>	Loc	<u>Oty</u>	Loc Code				
				FP001			18				_	
					102241		2		_		_	
					108289		16		_	<u> </u>	_	
D4095-049		Manufactured	No			260	Each	13.0000	1	1		1 ,
*D'4095-04 Wearpad Assembly	19 *								**	2		14/07/16
				Location	<u>l</u>	Loc	<u>Oty</u>	Loc Code				
				FP001			12					
					109670		12			χι	_	•
				FP002			1					
					102216		1		_		_	
D6014-090		Manufactured	No			100	Each	74.0000	1	1		
*D6014-09 ALUMINUM EXTRUSION									**			V-11-11-11-11-11-11-11-11-11-11-11-11-11

Location Loc Oty Loc Code LG003 74 17 86063 57

KC 14-03-07

DQA:	<u> </u>		Date:	'		WORK ORDER NON	~	SNEOI	DAAANGE / LI	DDATE				*	DART
QA Closed:			Date:			WORK ORDER NON	-((JNFOI	RIVIANCE / U		Wc	ork Order up	odate only		AEROSPACE
Work Orde	or.					DISPOSITION				AGAINST I	DE	PARTMENT	/PROCESS		
Part N	lo					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descr	iption of work order update		nitial	Act	ion		Sign &			
Cause	D	ate	Step	Qty		or non-conformance	1	ief Eng		ription	į	Date	Verificatio	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training		Date Step Qty													
Transport		i													
Unapproved	<u> </u>						EAI	ULT CAT	ECORY		1				
Landir	ng Gear		· · ·			General	17	oei cai	LOOKI						
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	\vdash	Grain Hardwa Inspecti Instruct Misalig Mislabe Misreac Off-set	on Incomplete/Ur ions Incomplete/U ned/off center led	- H		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/S	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Turning Sequence Wave/Twist in Tube					Fit/Function		1	Sequence		•				

Friday, March 07, 2014 9:20:35 AM Work Order ID: 114518 *114518* Parent Item: D3391-025 *D3391-025* Parent Item Name: Aft Tube Assembly Required Date: 3/14/2014 **Start Date:** 3/7/2014 Start Qty: 1.00 Required Qty: 1.00 D3670-4-200 No Manufactured 230 Each 337.0000 *D3670-4-200* Location Loc Qty Loc Code FG 10 87709 10 LG001 327 (103880 60 109108 242 96240 25 D2646 Manufactured No 270 Each 61.0000 ** Aft Cap Location Loc Qty Loc Code FG 85848 2

DQA:			Date:			MODE ODDED NON	c	ONICO	DNAANCE / LIDDA	TC				ART
QA Closed:			Date:			WORK ORDER NON	-((JINFUI	RIVIANCE / UPDA		ork Order up	odate only	A E R	OSPACE
Work Orde	25.					DISPOSITION			A		PARTMENT,			
Work Orde	er: —				<u> </u>	Damark	1					\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\		
Part N	ماه					Rework Scrap		l .	├ -	osstube nall Fab	Dec	Water Jet	Engineer	- -
raiti	v O	<u> </u>		···········		Use-as-is			<u> </u>	inishing	ı	d. Eng. Coor e/Packaging	Qua	her
NCR N	۱o					Suspected Unapproved		men	~ 	mposite	Nec/stor	Supplier		
Root					Descr	iption of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Ins	pector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator			:						·					
Offset/Setup														
Process														
Supplier			,			. !								
Training														:
Transport														
Unapproved														
							FAI	ULT CAT	TEGORY					
Landi	ng Gea	ir				General					•	_	_	
	Ве	ending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Fo	orced
* +	Ce	ntre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
	Cr	acks				Broken/Damage/Defect		Hardwa	re		Part Incorrec	t _	Temperatu	re/Cure
	Crimp/Kink/Ripple/Wave			/Wave		Burrs	L	Inspecti	ion Incomplete/Unqualif	fied	Part Lost/Mi	ssing	Weld	
	Cuffs					Contamination		Instruct	ions Incomplete/Unclea	ır	Part Moved		Wrong Stoo	ck Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned W	/rong _			
	Heat Treat					Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other	
	Inspection Strip in Tube					Drawing		Misread	d					
	Marks/Chatter					Drill Holes		Off-set			,			
	Tu	rning Se	equence			Finish		Out of 0	Calibration					
	Turning Sequence Wave/Twist in Tube					Fit/Function		Out of 9	Sequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print Friday, March 07, 2014 9:20:35 AM										Page 3
Work Order ID: 114518 Parent Item: D3391-025 Parent Item Name: Aft Tube Assembly		*1145 *D339	18* 1-025*				art Date: 3			ed Date: 3/14/2014
D3672-1 *D3672-1* Phenolic Washer	Manufactured	No		270	Each	1,676.000	2 **	2	Q id	07/16
ALS4-1032-130 AELS4-1032-130	Purchased	Location FG ST060	85222 103845 112218 113581 93886 99099	<u>L</u> 2	10 10 1666 4 500 500 450 212 Each	Loc Code 1,136.000	14		٨	1 1
AI S4-1032-130	·	<u>Locatio</u> ST279	M128179	<u>Lo</u>	0c Oty 1079 122	Loc Code	**		-	102116
ALS4-1032-225 AELS8-1032-225	Purchased	st510	M128211 M126109	270	957 *\^\ 57 57 Each	992.0000	8	8 X14	- - -	1 (
AI S4-1032-225		<u>Locatio</u> FG ST280	M127028 M127028 M127028 M128179	<u>L</u> .c	30 30 30 928 10 918	<u>Loc Code</u>	**) <u> </u> - - -	(ulo 2/16
Friday, March 07, 2014 9:20:35 AM		st555	M127092 Shop Pac	ket Print	34 34				_	Page 3

DQA:	_		Date:			WORK ORDER MON		2150	22442105 / 1	100475				*	TRAGG
QA Closed:			Date:			WORK ORDER NON	-C(JNFO	RIMANCE / U		W	ork Order u	odate only		AEROSPACE
						DISPOSITION						PARTMENT	•		
Work Orde	er:		***			DISPOSITION	_			AGAINST	DE	PARTIVIENT,	PROCESS -		
						Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part I	۷o					Scrap		!	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR I	No			·		Suspected Unapproved]		Large Fab	Composite			Supplier		
Root					Descr	ription of work order update		nitial	Ac	ction		Sign &			
Cause	[Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	۱	QC Inspector
Design															
Doc/Data															
Equip/Tooling															,
Handling/Pre															
Material							_								
Operator	Ш														
Offset/Setup												Ì			
Process	Ш														
Supplier															
Training															
Transport	Ш														
Unapproved						•									
							FAI	ULT CAT	TEGORY						
Landi	ng Gea	r				General						•	-		
	Bei	nding				Bend	<u> </u>	Folio/P	rogram			Outside Dim	ensions		Pressure/Forced
	Ce	ntre No	t Concer	ntric		BOM/Route	L	Grain				Over/Under	tolerance	_	Set-up
,	Cra	icks				Broken/Damage/Defect		Hardwa	re			Part Incorred	ct [Temperature/Cure
	Crimp/Kink/Ripple/Wave			/Wave		Burrs		Inspect	on Incomplete/U	Inqualified		Part Lost/Mi	ssing		Weld
	Cuffs					Contamination		Instruct	ions Incomplete/	'Unclear		Part Moved			Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center			Positioned V	Vrong	_		
	Heat Treat				Cut Too Short		Mislabe	led			Power Loss/	Surge		Other	
	Inspection Strip in Tube				Drawing		Misread	i							
	<u> </u> Ма	rks/Cha	atter			Drill Holes	L	Off-set							
	Turning Sequence					Finish		Out of (Calibration						
	Wave/Twist in Tube					Fit/Function		Out of 9	Sequence						

Friday, March 07, 2014 9:20:35 AM									Page 4
Work Order ID: 114518			145						
Parent Item: D3391-025		*D	339	1-025*					
Parent Item Name: Aft Tube Assembl	у						Start Date: Start Qty:		Required Date: 3/14/2014 Required Qty: 1.00
AN3C4A	Purchased	No			270	Each	2,081.000 6	6	
AN3C4A							**		l Modite
			Locatio	<u>on</u>]	Loc Oty	Loc Code		
			FG	122814		20 20	11128879	_ x (o	-
			ST512	124221		3 3			- -
			ST513			2058			-
				125388 M127410		1835 1			-
				M127832		222			• -
AN3C5A	Purchased	No			270	Each	1,089.000 4	4	
AN3C5A							**		11/07/16
			Locatio	<u>n</u>]	Loc Oty	Loc Code		
			FG			5			-
			CT2.50	122800		5	11128911	<u> x</u> 4	-
			ST350	M128057		1084 1084			· -
NAS1149C0332R	Purchased	No			270	Each	7,672.000 10	10	-
NAS1149C0332	R						**		Il 14/07/16
			Locatio	<u>n</u>]	Loc Oty	Loc Code		
			GA			1101	M 129499	X(O	_
				125654		1101			-
			st510	10/010		6571		<u> </u>	-
				m126319 m127306		61 2500			-
				m127410		3000			=
				m127831		1010			- -
Friday, March 07, 2014 9:20:35 AM			•	Shop Pac	ket Prin	t			Page 4

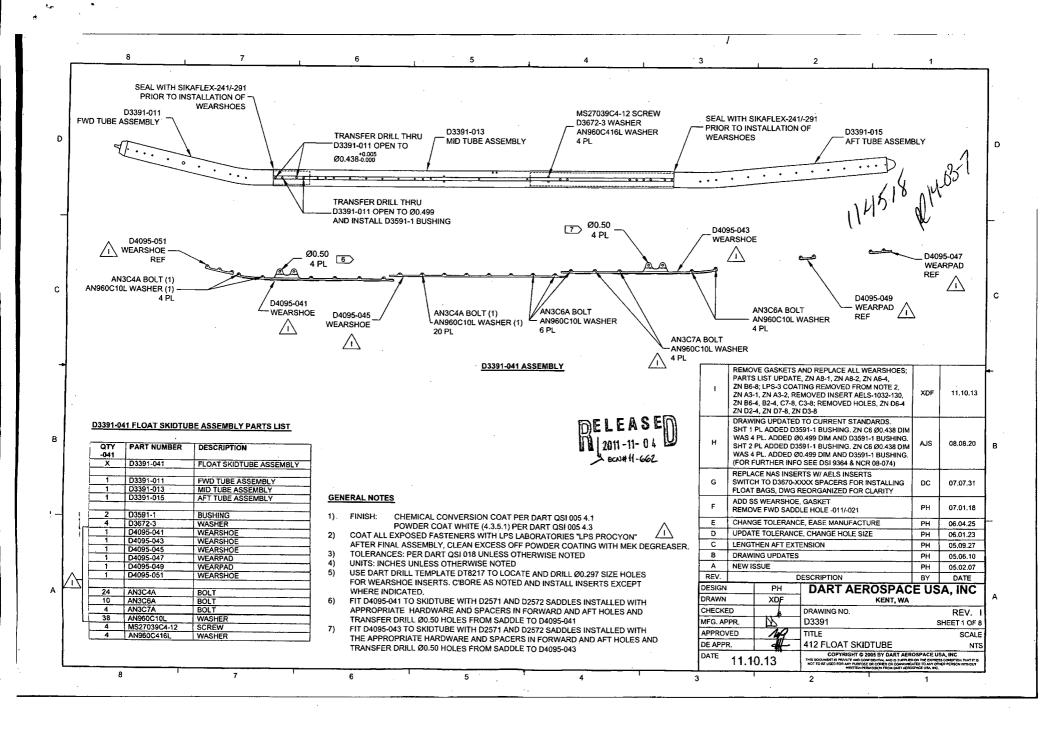
Shop Packet Print

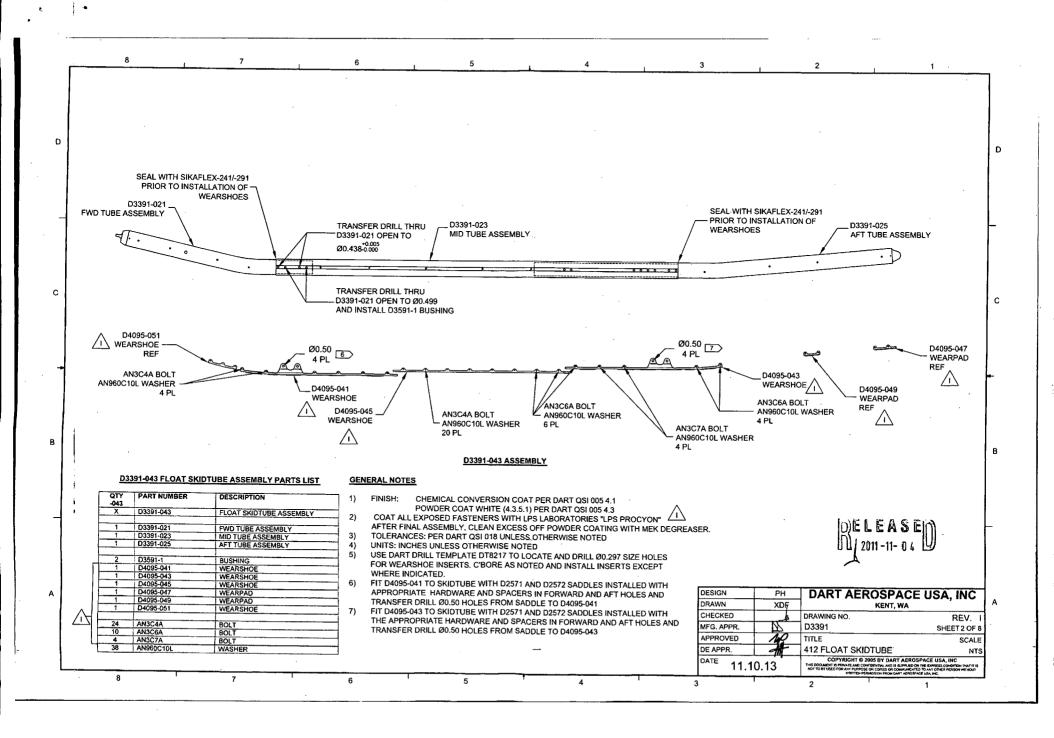
Page 4

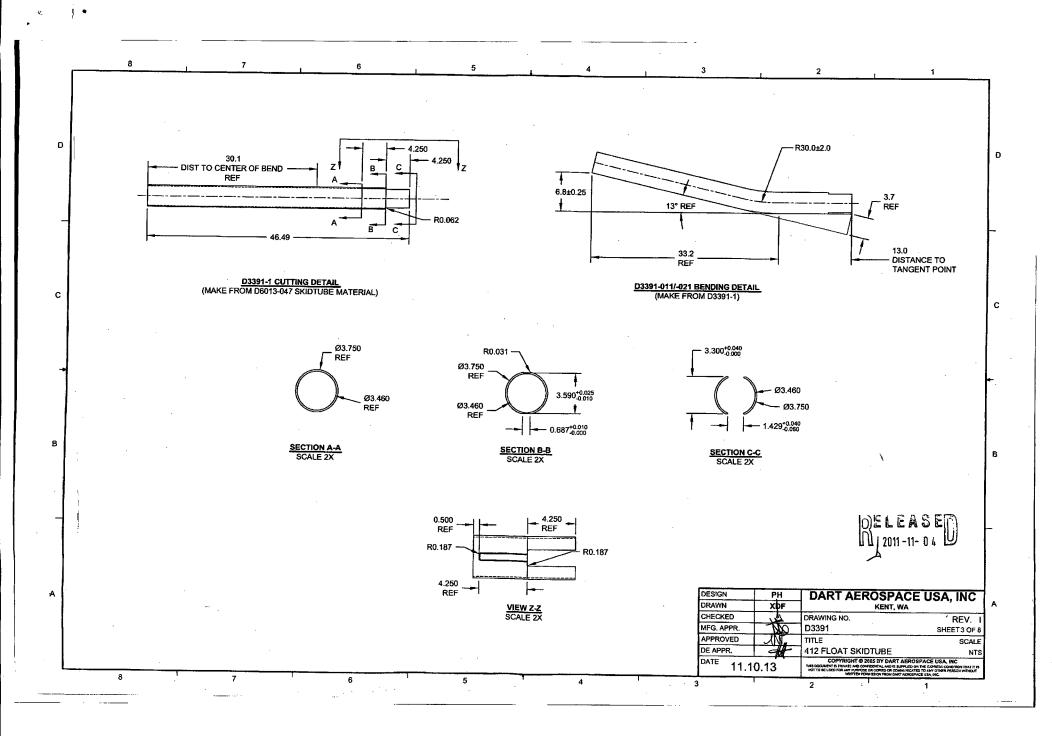
. Picklist Print

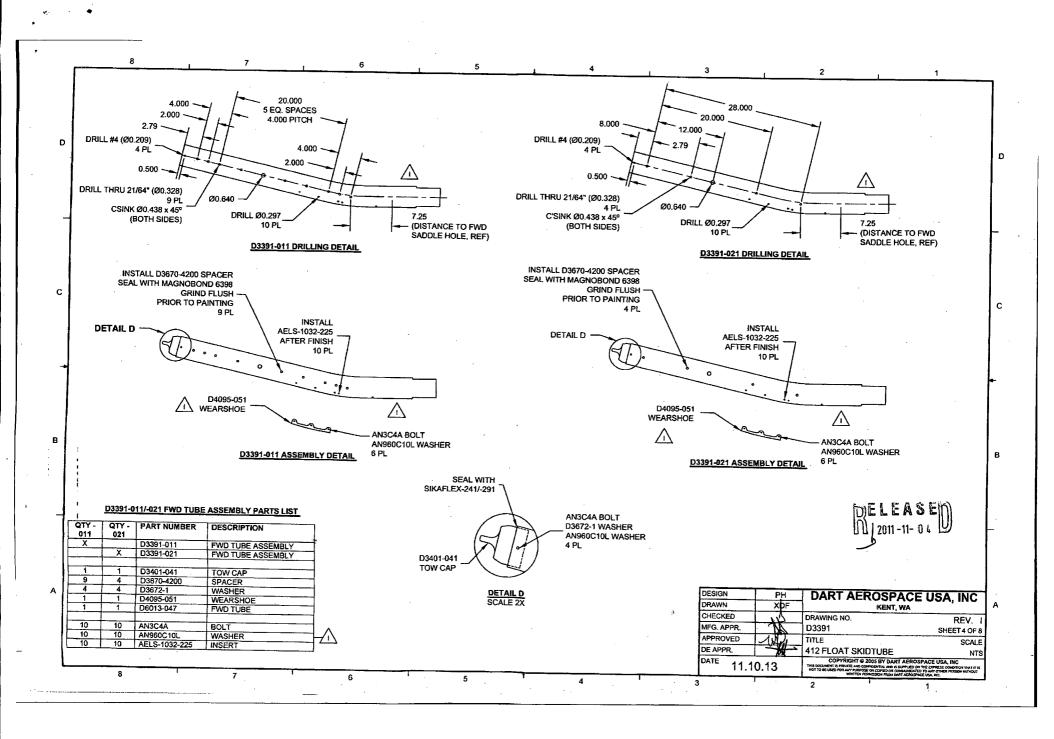
DQA:			Date:										DAR'	7
۵۸ ۵۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰۰			Data			WORK ORDER NON	-C(ONFO	RMANCE / UI				AEROSPAC	; E
QA Closed:			Date:		1					<u>\</u>	Vork Order u	odate only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Part N	-					Rework Scrap Use-as-is Suspected Unapproved		!	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				_	Descr	ription of work order update		nitial	Acti	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	1	ief Eng	Descri	iption	Date	Verification	QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		Date Step Qty												
							FA	ULT CAT	TEGORY					
Landi	ng G	ear				General		_				_		
•		g Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink		Grain Hardwa Inspecti Instruct	Program Ire Ion Incomplete/Un Iions Incomplete/U Ined/off center	· -	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	tolerance ct sssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulle	
	Heat Treat					Cut Too Short		Mislabe		<u> </u>	Power Loss/		Other:	
	Inspection Strip in Tube					Drawing	\vdash	Misread		L	·			
	Marks/Chatter					Drill Holes		Off-set				····		
	Turning Sequence					Finish		Out of (Calibration					
	Turning Sequence Wave/Twist in Tube					Fit/Function		Out of S	Sequence					

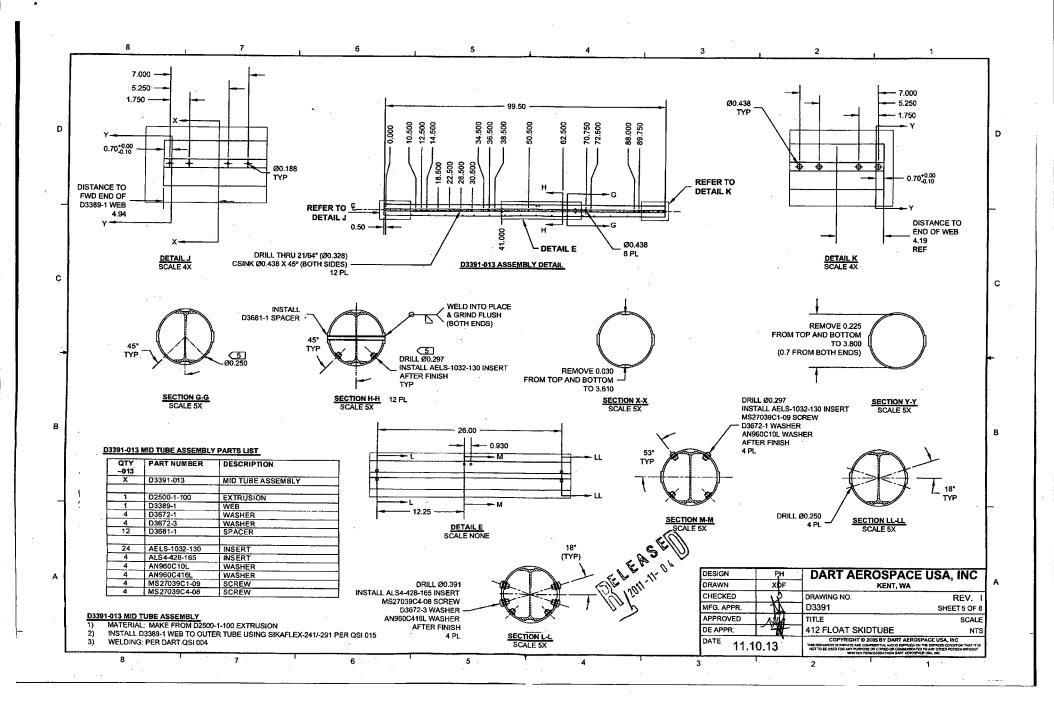
H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

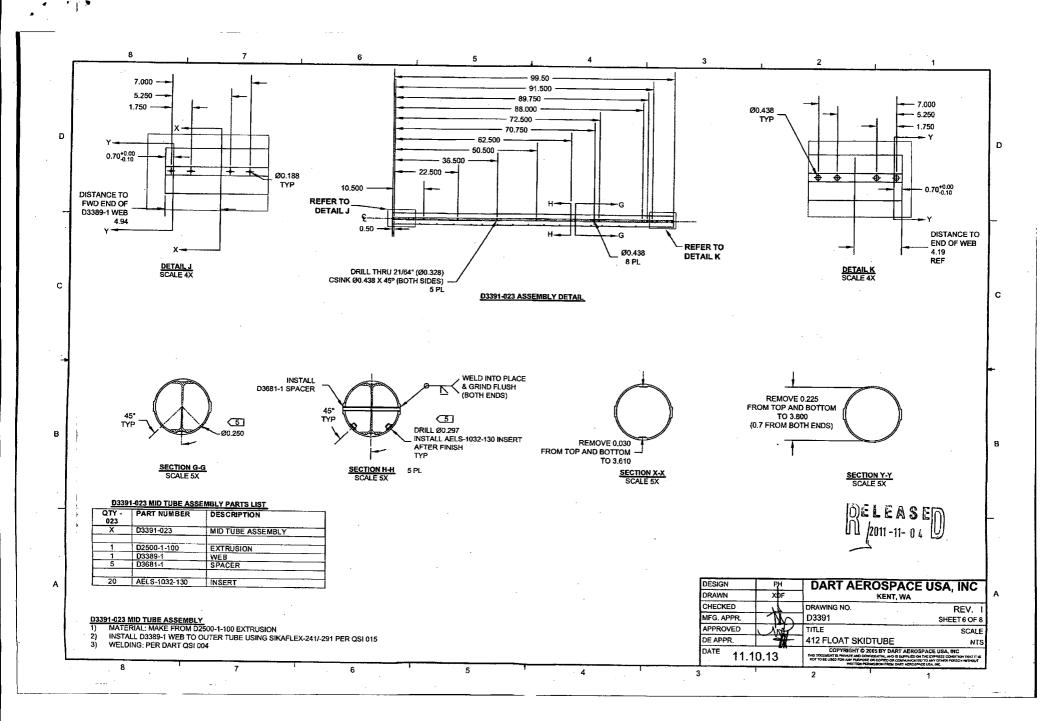


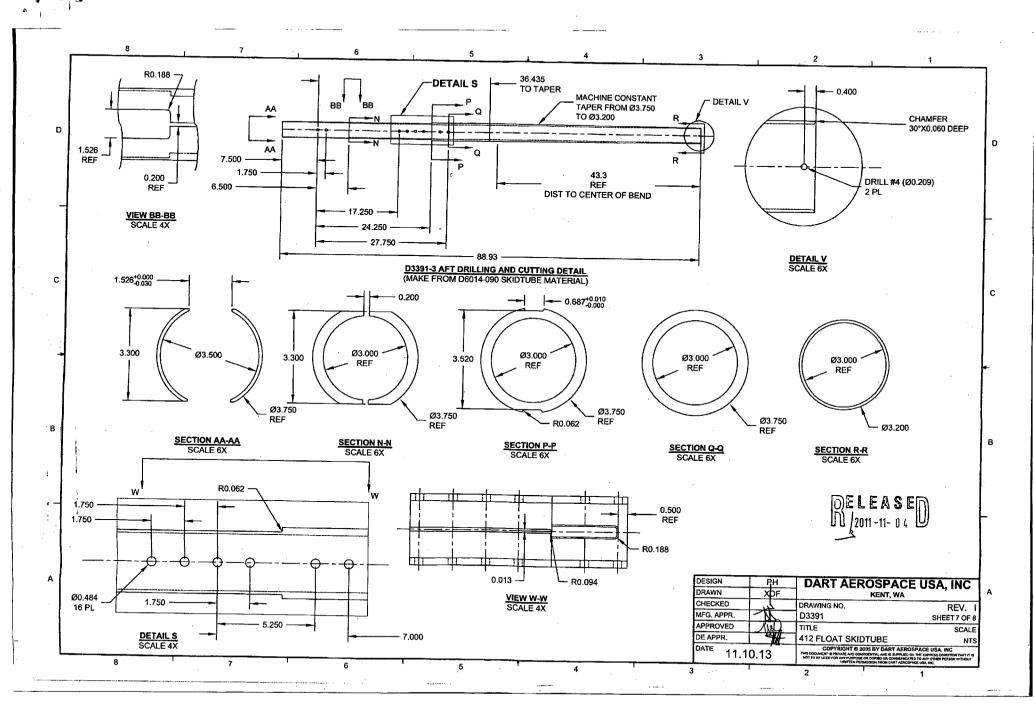






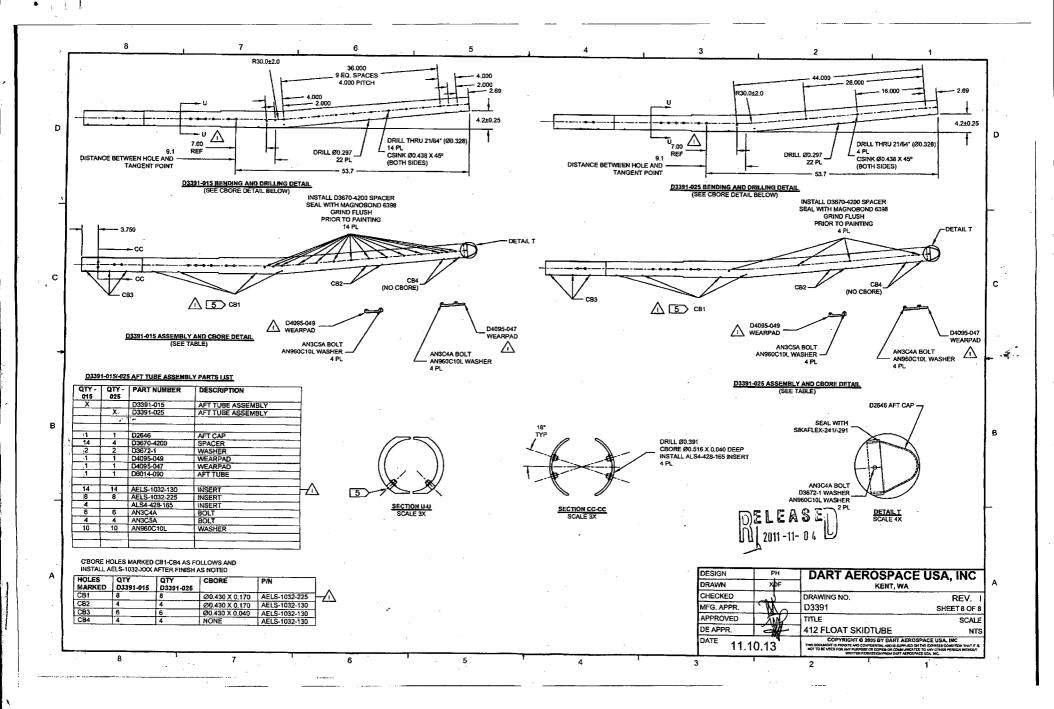






٠. .





			**************************************	÷`		,	·			of the order of th
• •		-	\$	en en en en en en en en en en en en en e						
· · · · · · · · · · · · · · · · · · ·				3 (1) 3 (1) 1 (3)			:			ign and and a
								r		
	į.	·	t.							
•					in.s				Marie de la companya	
								p.		A Company
			*							

DART AEROSPACE LTD	Work Order:	n engle
Description: Float Skidtube (412)	Part Number:	D3391-3
Inspection Dwg: D3391 Rev: I		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Tolerance Actual Dimension		Reject	Method of Inspection	Comments	
		Lat	he Section	n			
14.000	+/-0.010	14.00			tape	16-25	
3.500	+/-0.010	3.503			vern	CN2-08	
Ø3.200	+/-0.010	3-203			1		
Ø3.750	+/-0.010	3-250	_		1		
30° x 0.060 chamfer	+/-0.010	30°× .060			1)		
88.93	+/-0.030	88,93			type	LG-25	

Measured by: 970/7. L

Audited by: 5775

Date: 14/23/08

Date: 14/3//2

	HAAS Section										
1.526	+0.000/-0.030	1.505		Vem	111-06						
7.500	+/-0.010	7-500		11	,						
27.750	+/-0.010	27.750		M-tope	21-08						
31.750	+/-0.010	31.750		11							
35.250	+/-0.010	35.250		3.7							
3.300	+/-0.010	3.303		Vern	M2-D6						
0.200	+/-0.010	,200		C							
3.520	+/-0.010	3.526									
0.687	+0.010/-0.000	. 687		·							
R0.062	+/-0.010	R.662									
Ø0.484	+0.005/-0.001	00.487	/								

Measured by: 14 PM Date: /4/03/17

Audited by: DAS Date: /4/03/19

Rev	Date	Change 9-89	Revised by	Approved
Α	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
В	06.06.19	Dwg revision update	KJ/JLM -	
С	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
Н	11.06.21	Dimension 44.995 removed	KJ	
$\overline{}$	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ 1A	
L	12.11.28	88.93 dimension added	KJ 😽	

DQA:	-	D	ate: _											
	4		· •	10 mm	ı., .	WORK C	DRDER NON	-CC	ONFO	RMANCE / I	UPDATE			AEROSPACE
QA Closed:	*1,	D	ate:	તે કે ક		¥'s ,					W	/ork Order uរុ	odate only	
Work Orde	er:	• *		*****		DISP	OSITION		•		AGAINST D	EPARTMENT,	/PROCESS	
Part No.			Rework Scrap				Skid-tube Machining	Crosstube Small Fab	-	Water Jet Engineering Prod. Eng. Coor. Quality				
NCR No.				Suspected L	Use-as-is Jnapproved			moforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other		
Root	1	10 + 1	•		Desci	ription of work	order update	П	nitial	A	ction	Sign &	\$	
Cause	Da	te St	ер	Qty		or non-confo	•	ł	ief Eng	1	cription	Date	Verification	QC Inspector
Design Doc/Data			-						-2	- C	*	, 5 7		A Mag
Equip/Tooling Handling/Pre Material					١			i,					•	
Operator Offset/Setup						g vin			1 1		. •		•	
Process Supplier. Training			- 1 m	5. •			****	A	4	-44 d	· · · · · · · · · · · · · · · · · · ·			
Transport** Unapproved:	•						American for		1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		F 10	0		
		, .·`		•		40	44.	FA	ULT CA	TEGORY	<i>/</i>	<u>つこ</u>	·-	. * :
Landir	ng Gear	e de la companya de l				Gene	eral 🗼					, -	* .	
क् क र	Bend	_				Bend	* *		1	Program		Outside Dim	5 (A) 1 (A)	Pressure/Forced
	Cent	re Not Co	ncen	tric	\vdash	BOM/Route Broken/Dama	age/Defect		Grain Hardwa	aro.		Over/Under Part Incorre	· -	Set-up Temperature/Cure
·	_	ks p/Kink/Ri	pple/	'Wave	غ نور	Burrs	ige/ Delect		1	ion Incomplete/	Unqualified —	Part Lost/Mi		Weld
	Cuff			,	-	Contamination			• • • • • • • • • • • • • • • • • • • •	tions Incomplete	-	Part Moved		Wrong Stock Pulled
	Crus	-	, - ,	ر مهاجي	· [Countersink	¥ .		1	gned/off center	r / [Positioned V		-
· .		Treat 1		***		Cut Too Short	· .	<u> </u>	Mislab			Power Loss/	Surge	Other
		ection Str	•	Гube		Drawing		\vdash	Misrea				<u></u>	
		cs/Chatte			_	Drill Holes	1975 2 T	\vdash	Off-set	•				
		ing Seque e/Twist in			- -	Finish Fit/Function	1 96 4	\vdash	4	Calibration . Sequence			•	
1 - 1	iwav	er i wist if	เเนติ	=	- 1	IFIL/FUNCTION	•	l .	IOUL OF	seuuence			,	\$55